

Date: Wednesday, 6/28/2006 4:17:32 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEB
Job Number	: 27740		Part Number	: D2739
Estimate Number	: 10498		Drawing Number	: D2739 REV C
P.O. Number	: N/A		Project Number	: N/A
This Issue	: 6/28/2006 S.O. No. : N/A		Drawing Revision	: C
Prsht Rev.	: NC		Material	: N/A
First Issue	: N/A		Due Date	: 7/30/2006
Previous Run	: 27665		Qty:	4
Written By	: <i>SG</i> (Comment Below)		Um:	Each
Checked & Approved By	: <i>DK</i> 06-06-29			
Comment	: Est Rev: C 02.11.28 Reformat KJ Est Rev: D 06-03-21 As Per Rev C JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D26005108	Extrusion 'I Beam' thin
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Extrusion 'I Beam' thin Pick: Qty Part Number Description Batch 1 D2600-5 Web <i>B24410 Pm 06-07-10 (4)</i>
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
		Comment: LANDING GEAR RESOURCE 1 1-Cut D2600-5 to length as per Dwg D2739 <i>Pm 06-07-10 (4)</i> 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739 <i>Pm 06-07-11 (4)</i> 3-Use uni-bit to open holes to finish size as per Dwg D2739. <i>Pm 06-07-11 (4)</i> 4-Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends. <i>Pm 06-07-11 (4)</i> 5-Dburr <i>Pm 06-07-11 (4)</i>
3.0	QC5	INSPECT WORK TO CURRENT STEP
		Comment: INSPECT WORK TO CURRENT STEP <i>DP 6-7-13 (4)</i>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 DQA: 

Date: 06/07/25

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

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Seq. #:

Machine Or Operation:

Description :

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

XP 06-07-13

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



DP 6-7-13 (4)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock
Location: LG

DP 6-7-13

(4)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06-07-14

Job Completion



06-07-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

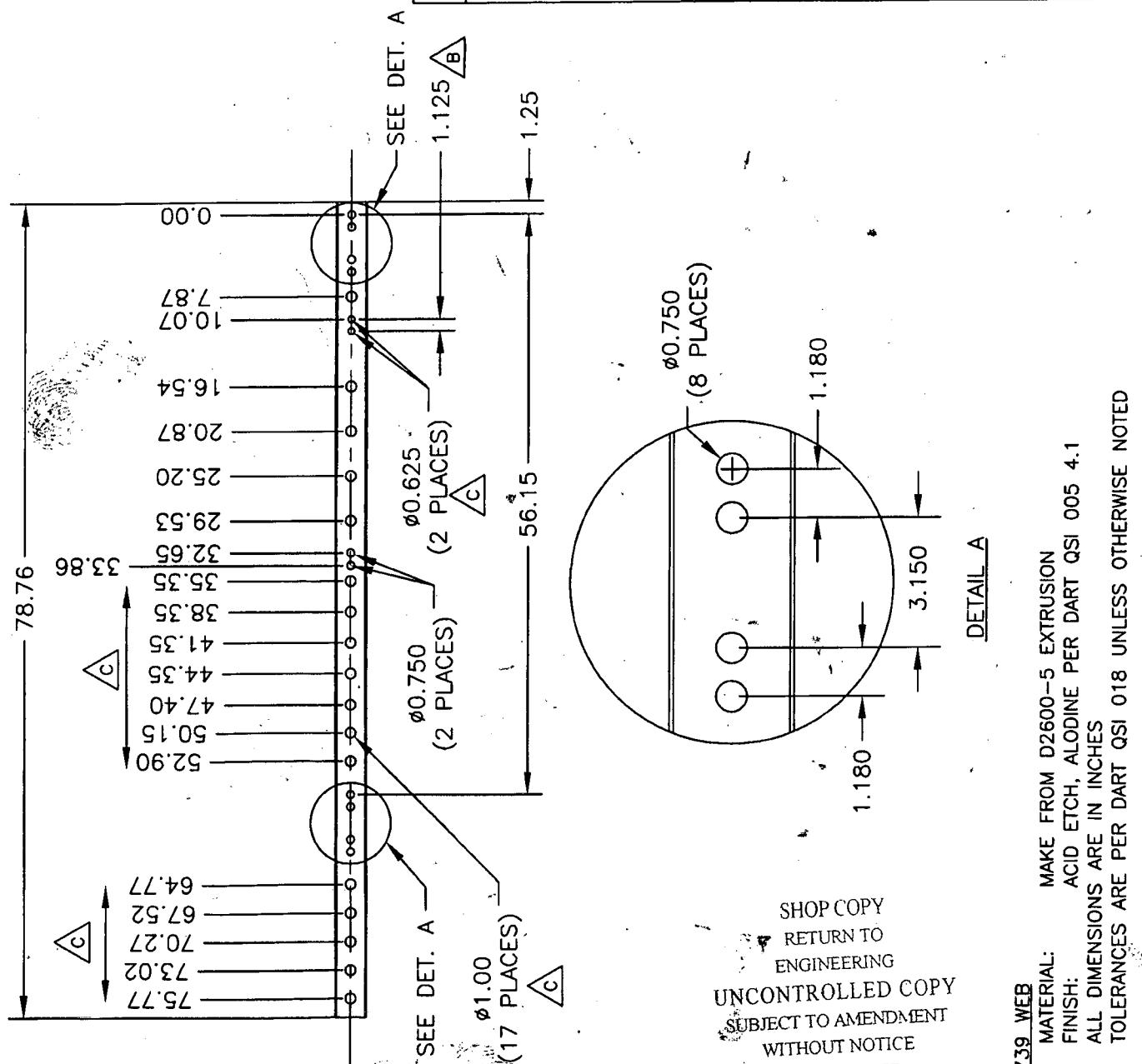
NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART

DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2739	REV. C SHEET 1 OF 1
DATE 06.01.05	TITLE WEB		SCALE 1:15
A	98.04.16	NEW ISSUE	
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS	
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS	

RELEASED
06-02-57 11

06-02-07 11



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27740

D2739 WEB

ERIAL: MAKE FROM D2600-5 EXTRUSION
SH: ACID ETCH, ALODINE PER DART QSI 005 4.1
SH: DIMENSIONS ARE IN INCHES
ERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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